

Date: Tuesday, 4/4/2006 1:27:08 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services.		Drawing Name	: LITTER TIE DOWN ASS'Y (LOCKING)		
Job Number	: 26489					
Estimate Number	: 10495					
P.O. Number	: N/A			Part Number	: D2360	
This Issue	: 4/4/2006 S.O. No. : N/A			Drawing Number	: D2360 / D2341	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: C1 / E	
Previous Run	: 26443			Material	: N/A	
Written By	: <i>Sid J. COMMENT Below</i>			Due Date	: 4/24/2006	
Checked & Approved By	: <i>JH 06.04.04</i>			Qty:	4 Um: Each	
Comment						

## Additional Product

Job Number:	
Seq. #:	Machine Or Operation:
1.0	D6201
	
Comment:	Qty.: 1.1067 f(s)/Unit Total : 4.4268 f(s) Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion) Batch: <i>B26538</i>
2.0	BAND SAW
	
Comment:	BAND SAW Cut blanks: 12.65" Long
3.0	HAAS1
	
Comment:	HAAS CNC VERTICAL MACHINING #1 Machine as per Folio D2341 and Dwg D2341
4.0	QC2
	
Comment:	INSPECT PARTS AS THEY COME OFF MACHINE
5.0	QC8
	
Comment:	SECOND CHECK
6.0	HAAS1
	
Comment:	HAAS CNC VERTICAL MACHINING #1 Deburr and Tumble

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.05.07	6	During tumbling 2 parts stuck together and caused damage on the edge of one part .020" deep in 2 locations.  See photo's.		Fill damaged areas with weld, and grind flush to drawing dimensions AS per QSI 004.	J.D 06.05.08 J.E. 06.05.8 60508		8 May 08	

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26489

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

4 H.M 06/05/09

9.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

4 H.M 06-05-16

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0 D2002015

Knob



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Knob

Batch B16177B

12.0 D2345

Lock Channel



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Lock Channel

B26457

13.0 D2366

Lock Handle



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Inventory

B19288

14.0 D2367

Handle Knob



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Inventory

B26597

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:27:09 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26489

Part Number: D2360

Job Number:



Seq. #:	Machine Or Operation:	Description :
15.0	D2372	Quick Release 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Quick Release <i>B26497(3) B19508(1)</i>
16.0	D2373	Spring 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Spring <i>B19508 (3) B26458 (1)</i>
17.0	D2444	Pip Pin Assembly 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Pip Pin Assembly <i>B25824</i>
18.0	AN526C1032R18	Screw 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Screw <i>M14523</i>
19.0	AN960JD10	Washer 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Washer <i>M18235 M100743</i>
20.0	AN960JD10L	Washer 
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s) Washer <i>M18235</i>
21.0	MS20470AD34	Rivet,Universal Head 
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Rivet,Universal Head <i>M15541</i>
22.0	MS21042L3	Nut 
		Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s) Nut <i>M18917</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/4/2006 1:27:09 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y (LOCKING)

Job Number: 26489

Part Number: D2360

Job Number:



Seq. #: Machine Or Operation:

Description :

23.0 MS27039113 Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Screw

M13719

24.0 MS27039115 Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Screw

M15432

25.0 NAS679A3W Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Nut

M1463

26.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
Assemble as per dwg D2360

SAD 06.05.18

(1)

27.0 QC5 INSPECT WORK TO CURRENT STEP



06-05-18 (1)

Comment: INSPECT WORK TO CURRENT STEP

28.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: SD 171

10.10.19 (4)

29.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



✓ 06.05.23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>BW</i>	DRAWN BY <i>Bob</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>DiOY</i>	DRAWING NO. D2360	REV. C SHEET 1 OF 2
DATE 97.08.27	TITLE LITTER TIE DOWN ASSEMBLY (LOCKING)		SCALE
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
<i>C1</i>	<del><i>02.09.24</i></del>	<i>D2002-015</i> WAS D2376	

**RELEASED**  
97.08.27 BW

D2360		Part No.	Description
X		D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341		LITTER TIE DOWN (LOCKING)
1	D2345		LOCK CHANNEL
2	D2366		LOCK HANDLE
1	D2367		KNOB (DELRIN)
2	D2372		QUICK RELEASE FASTENERS
1	D2373		SPRING
2	<del>D2376</del>		KNOB (DELRIN) <i>D2002-015</i>
1	D2444		PIP PIN
1	AN526C1032R18		SCREW
<del>3</del> 2	AN960JD10		WASHER
<del>5</del> 3	AN960JD10L		WASHER
1	MS20470AD3-4		RIVET
3	MS21042L3		NUT
1	MS27039-1-13		SCREW
2	MS27039-1-15		SCREW
1	NAS679A3W		NUT

KE 97.03.02

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WITHOUT NOTICE  
WORK ORDER  
NO. *26489*

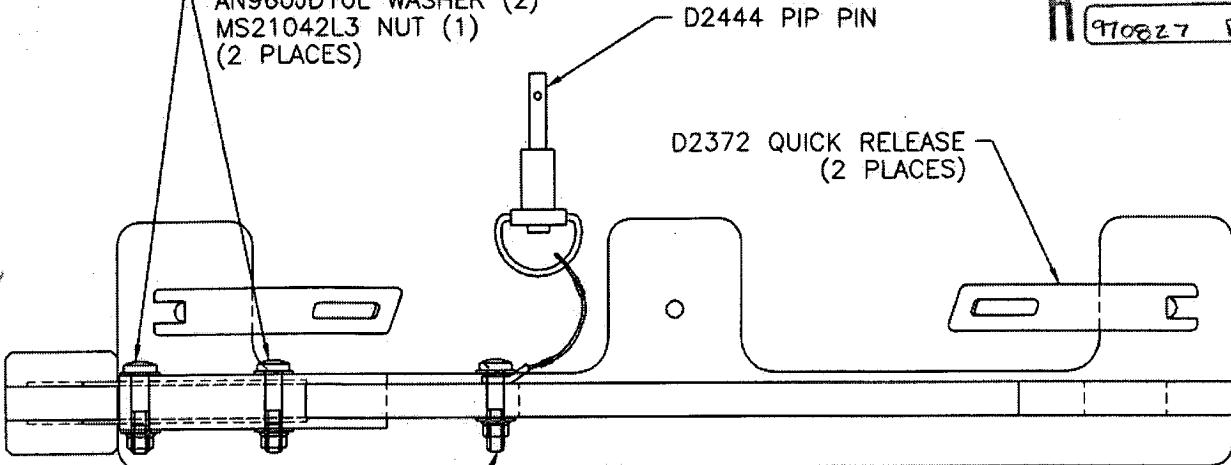


COPY ISSUED  
BY

DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>KE</i>	APPROVED <i>MJ</i>	DRAWING NO. D2360
DATE 97.08.27	TITLE	REV. C SHEET 2 OF 2 SCALE LITTER TIE DOWN ASSEMBLY (LOCKING)

MS27039-1-15 SCREW (1)  
AN960JD10L WASHER (2)  
MS21042L3 NUT (1)  
(2 PLACES)

RELEASED  
970827 BW



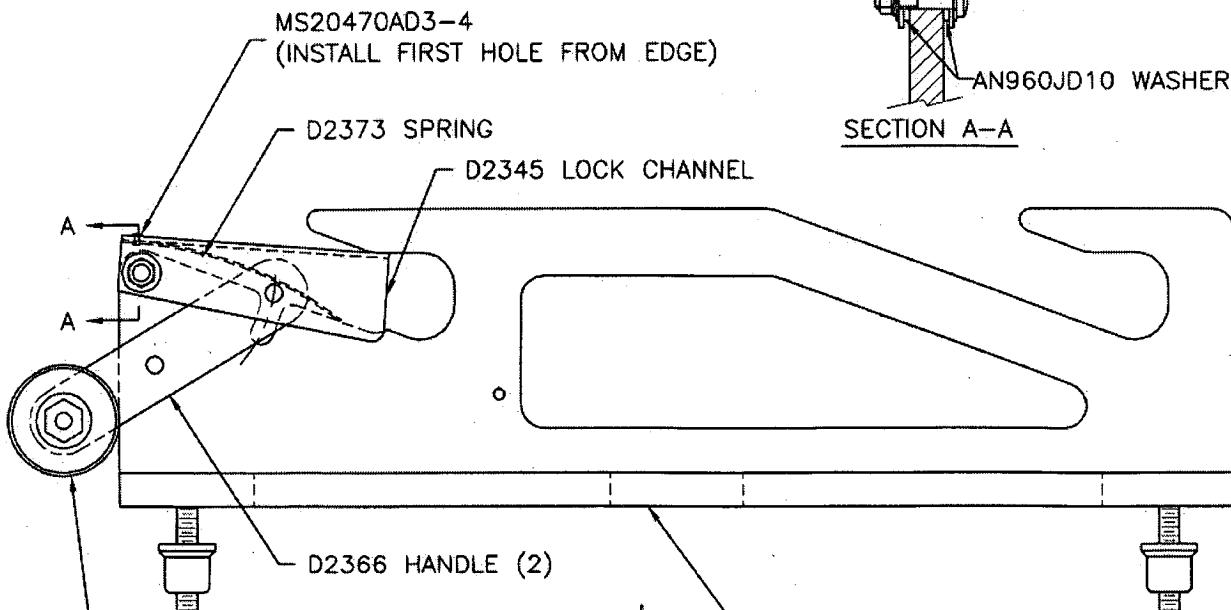
MS27039-1-13 SCREW  
AN960JD10L WASH (3)  
MS21042L3 NUT

KE 99.07.02

MS27039-1-15 SCREW (1)  
AN960JD10L WASHER (2)  
MS21042L3 NUT (1)  
(REF)

AN960JD10 WASHER (2)

SECTION A-A



D2376 KNOB (2)  
D2002-015 KNOB (2)  
D2367 KNOB (1)  
AN526C1032R18 SCREW (1)  
AN960JD10L WASHER (1)  
NAS679A3W NUT (1)

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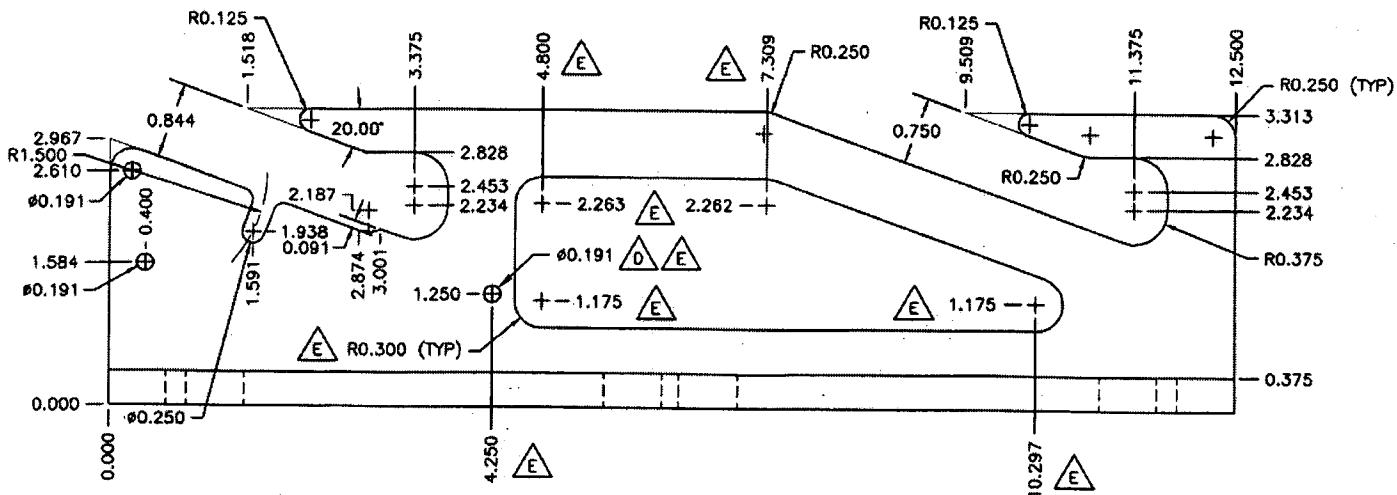
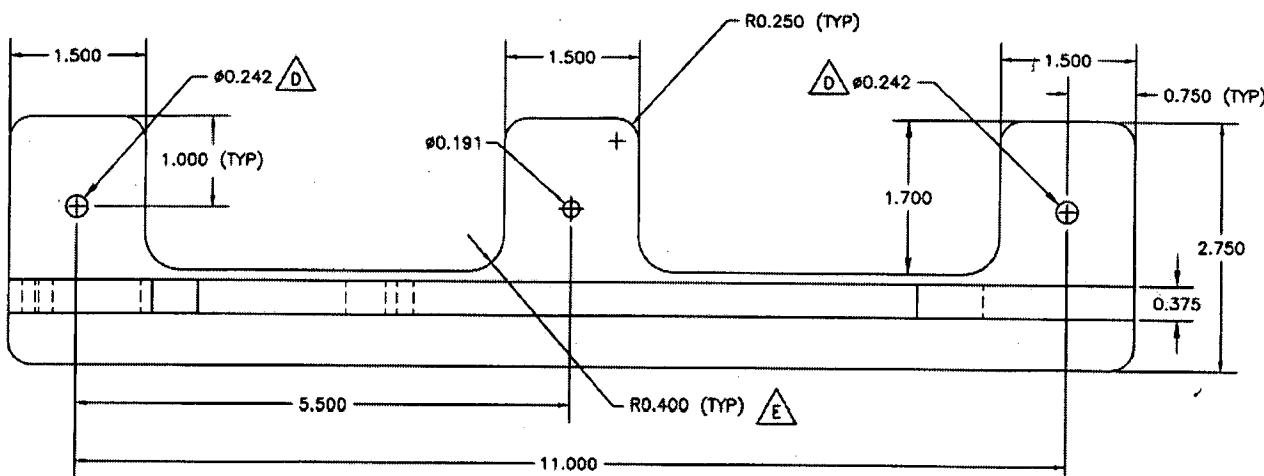
WORK ORDER  
NO. 26489

**DART**



DESIGN <i>BS</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BS</i>	APPROVED <i>BS</i>	DRAWING NO. D2341	REV. E SHEET 1 OF 1
DATE 97.10.01		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	

**RELEASED**  
971003 KE  
TSR A130



MATERIAL: 6061-T6 (QQ-A-200/8) 4X4X3/8 'T' SECTION  
FINISH: ANODIZE

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WITHOUT NOTICE  
WORK ORDER  
NO. *26489*

26489

## Work Order:

Part Number: D2341

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Page 1 of 1

R 2

## FIRST AID KIT INSPECTION CHECKLIST

Editorial

Prototype

	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.500	1.502	/				
1.000	1.005	/				
Ø 14.2	Ø 12.47	/				
Ø 19.1	Ø 19.1	/				
R. 250	R. 250	/				
1.700	1.698	/				
1.750	1.754	/				
2.150	2.156	/				
11.000	10.996	/				
5.300	5.301	/				
1.584	1.586	/				
Ø 19.1	Ø 19.1	/				
2.610	2.612	/				
844	842	/				
1.250	1.2493	/				
750	752	/				
12.300	12.302	/				
3.313	3.314	/				
4.250	4.250	/				
400	402	/				

VS

Audited by: J. E.  
Date: 06/05/08

Prototype Approval: N/A  
Date: N/A

Revised by Approved

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